

Work Order ID 86257

\*86257\*

Page 1

June-25-12 10:51:54 AM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 25/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/25

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

DAS 16 9-5 17/6/26

MLJ 12-7-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86257

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Item ID: D350-636-012

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

**\*110\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BE 12/07/11

BE 12/07/11

BB 12/07/16

BB 12/07/16

BB 12/07/16

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-636-012

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Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004  
A/R Aluminum Rod batch: M1222130

12-Grind welds flush as per Dwg D2750

*3 BE 12/07/11*

120  
**\*120\***  
QC  
Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

*DAS 16*

*12/07/17*

130  
**\*130\***  
QC  
Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

*DAS 16*

*12/07/17*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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				24/3 31 2011				

**NOTE:** Date & initial all entries

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00				1	76	12-7-17	
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
						①	SAD	12-07-17	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

**\*160\***

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 122130 exp. date: 13/3/14

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M122130

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

*BB 12/07/17*

*BB 12/07/17*

*BB 12/07/18*

*12-07-18*

*BB 12/07/18*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

DAS  
16  
8-8 17/07/23

12/07/18

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

DAS  
16  
8-8 17/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

*1/0* *BLD 7-23*

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: *2:30*

OVEN TEMPERATURE: *320 °F*

FINISH TIME: *3:00*

*IX* *MZ* *12/07/23*

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

*1 RH* *2P* *12/07/24*

*M121841*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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June-25-12 10:51:54 AM

**\*86257\***

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Item ID: D350-636-012

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>122130</u> EXP DATE: <u>14/07</u>								
	5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>110 349</u>								
	6-Coat all exposed fasteners with "LPS Procyon" batch: <u>114 596</u>								

1 RH 8 (2P) 12/07/24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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	3							

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**\*N900040100\***

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Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00 **\*1\***

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Required Date: 10/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 <b>*240*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
250 <b>*250*</b> Packaging Packaging	Pick Kit  Memo	0.00 0.00							
260 <b>*260*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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**Required Date:** 10/07/2012      **Req'd Qty:** 1.00      **\* 1 \***

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**Approvals:**    **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
                  **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

[illegible]

12-07-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

June-25-12 10:51:59 AM

Page 1

Work Order ID: 86257

\*86257\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	23.0000	1	1			

\*D2600-3-BENT\*

Extrusion Bent

\*\*

BE 12/07/11  
B 86330 \*1

Location	Loc Qty	Loc Code
LG	23	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
83442	7	

D2744

Manufactured No

110

Each

68.0000

1

1

\*D2744\*

Cap

\*\*

BE 12/07/11

Location	Loc Qty	Loc Code
LG002	68	
62715	1	
83412	29	
85506	38	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

11.0000 1 1

\*D2739\*

350 I Beam

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(1)

BE 12/07/12

Location

Loc Qty

Loc Code

LG

11

72155

1

81508

1

83447

3

83448

4

83548

2

D2743

Manufactured No

160 Each

240.0000 8 8

\*D2743\*

Crossbolt Spacer

\*\*

BE 12/07/12

Location

Loc Qty

Loc Code

LG

166

81965

39

83262

127

LG001

74

67766

4

68251

3

73403

64

74445

1

79517

2

D3490-3

Manufactured No

160 Each

102.0000 4 4

\*D3490-3\*

Cross Bolt Spacer

\*\*

BE 12/07/12

Location

Loc Qty

Loc Code

LG001

102

83313

42

85420

60

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

111.0000

4

4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BER/07/18

## Location

## Loc Qty

## Loc Code

LG

88

81976

2

85419

86

LG001

23

62450

2

74875

4

77042

3

83269

14

D3631-1

Manufactured No

230

Each

283.0000

8

8

\*D3631-1\*

Washer

\*\*

8

2P

12/07/23

## Location

## Loc Qty

## Loc Code

FG

268

81874

2

83588✓

266

ST072

15

68062

2

75548

13

D3791-1

Manufactured No

230

Each

26.0000

1

1

\*D3791-1\*

Wearplate

\*\*

1

2P

12/07/23

## Location

## Loc Qty

## Loc Code

FP002

26

62239

2

83392✓

12

83902

12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

28.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

1 (2P) 12/07/24

## Location

## Loc Qty

## Loc Code

FP001

28

83394

16

83901 ✓

12

MS21043-6

Purchased No

230

Each

586.0000

4

4

\*MS21043-6\*

NUT

\*\*

4 (2P) 12/07/24

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST301

566

117887

2

118384 ✓

64

120308

500

D3794-1

Manufactured No

230

Each

24.0000

1

1

\*D3794-1\*

Gasket

\*\*

1 (2P) 12/07/24

## Location

## Loc Qty

## Loc Code

FP

4

82167

4

FP002

20

83395 ✓

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

**\*86257\***

**\*D350-636-012\***

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

416.0000

8

8

\*\*

8

*SP*

*12/07/24*

**\*NAS1611-010\***

O-RING

Location

Loc Qty

Loc Code

FP001

416

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121584

2

121723

39

122151 ✓

300

D2741

Manufactured

No

250

Each

43.0000

1

1

\*\*

1

*JB*

*Q*

**\*D2741\***

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

53

71856

1

79516

3

83135

39

*83135*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

312.0000

4

4

\*NAS1515H3I \*

WASHER

\*\*

4

(24)

12/07/24

## Location

## Loc Qty

## Loc Code

FG

40

102472

40

ST277

272

118686

3

119438 ✓

1

120360

11

121556

57

122151

200

NAS1611-013

Purchased

No

230

Each

317.0000

8

8

\*NAS1611-013\*

O-RING

\*\*

8

(24)

12/07/24

## Location

## Loc Qty

## Loc Code

FP001

317

116582

5

117291

2

117887

53

119623

36

121584

5

121825 ✓

174

121826

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

335.0000

4

4

\*AN3C6A\*

BOLT

\*\*

4

2P

12/07/24

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

334

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

118

121682 ✓

124

NAS1149C0832R

Purchased

No

230

Each

250.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

1

2P

12/07/24

Location

Loc Qty

Loc Code

ST297

250

114915 ✓

250

D3536-25

Manufactured

No

230

Each

26.0000

1

1

\*D3536-25\*

Gasket

\*\*

1

2P

12/07/24

Location

Loc Qty

Loc Code

FP

26

83391

10

83900 ✓

16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

21.0000

1

1

\*D3794-3\*

Gasket

\*\*

1

(20)

12/07/24

## Location

## Loc Qty

## Loc Code

FP

19

83396 ✓

19

FP002

2

74530

2

AN3C5A

Purchased No

230

Each

1,688.000

34

34

\*AN3C5A\*

Bolt

\*\*

34

(20)

12/07/24

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

1681

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255 ✓

500

121444

68

121708

500

122141

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

82.0000

3

3

\*\*

3

DP

12/02/24

\*D3537-1\*

Wearpad

Location

Loc Qty

Loc Code

FP002

85457✓

82

81362

3

83254

1

83255

3

83256

25

85458

50

D3535-25

Manufactured No

230

Each

32.0000

1

1

\*\*

1

DP

12/07/24

\*D3535-25\*

Wearshoe

Location

Loc Qty

Loc Code

FP001

62233

32

81357

1

83387

17

83899✓

13

D3492-3

Manufactured No

230

Each

139.0000

8

8

\*\*

8

DP

12/07/24

\*D3492-3\*

Plug

Location

Loc Qty

Loc Code

FP-A

81967

139

83099

5

83529

12

85461✓

122

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 10

Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

~~NAS1149C0332~~ R Purchased

No

230

Each

21.0000

38

38

\*AN960C10I \*

washer

122063 ✓

\*\*

38 (2P) 12/07/24

Location

Loc Qty

Loc Code

ST

21

107534

21

D3488-042

Manufactured

No

230

Each

16.0000

1

1

\*D3488-042\*

Blade Fitting Assembly, RH

\*\*

1 (2P) 12/07/24

Location

Loc Qty

Loc Code

FP

-1

83417

11

FP002

17

85734

5

ALS4-1032-225

Purchased

No

230

Each

492.0000

38

38

\*AI S4-1032-225\*

Insert

\*\*

38 (2P) 12/07/24

Location

Loc Qty

Loc Code

ST281

469

108696

146

110768

62

118386

55

118966

68

121269

138

ST282

23

120410

10

120451

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

205.0000

8

8

\*D3492-1\*

Plug

\*\*

8

OP

12/07/24

## Location

## Loc Qty

## Loc Code

FP002

198

69531

8

74444

2

76235

4

83259 ✓

184

FP-A

7

83098

7

D3793-1

Manufactured No

230

Each

26.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

1

OP

12/07/24

## Location

## Loc Qty

## Loc Code

FP001

26

82171

2

83393 ✓

11

83903

13

AN8C35A

Purchased No

230

Each

61.0000

1

1

\*AN8C35A\*

BOLT

\*\*

1

OP

12/07/24

## Location

## Loc Qty

## Loc Code

FP002

60

115960

1

118286

9

121275 ✓

50

ST346

1

114442

0

115188

0

115960

1

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

108.0000

1

1

\*MS21083C8\*

NUT

\*\*

1

(2P)

12/07/24

Location

Loc Qty

Loc Code

304

53

121185 ✓

22

121349

31

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

D2745

Manufactured

No

230

Each

258.0000

8

8

\*D2745\*

Bushing

\*\*

8

(2P)

12/07/24

Location

Loc Qty

Loc Code

FP

206

79518

6

85416 ✓

200

FP001

52

69529

1

76142

1

83260

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

58.0000

4

4

\*AN6C44A\*

BOLT

\*\*

4

12/07/24

Location

Loc Qty

Loc Code

FG

122204✓

2

1

103964

2

ST343

56

121013

11

121440✓

45

3

Manufactured

No

250

Each

28.0000

2

2

D3532-1

\*D3532-1\*

Spacer

\*\*

2

JB

Location

Loc Qty

Loc Code

ST053

28

82041

3

83319

25

83319

Purchased

No

250

Each

108.0000

2

2

MS21083C8

\*MS21083C8\*

NUT

\*\*

2

JB 12/07/25

Location

Loc Qty

Loc Code

304

53

121185

22

121349

31

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

122141

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86257

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*86257\*

\*D350-636-012\*

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

235.0000

2

2

\*\*

\*NAS1149D0863.1\*

WASHER

Location

Loc Qty

Loc Code

ST298

235

118078

34

119307

1

120308

100

121556

100

120308

D3493-1

Manufactured

No

250

Each

111.0000

2

2

\*\*

\*D3493-1\*

Washer

Location

Loc Qty

Loc Code

ST050

111

77573

1

82023

10

83097

100

83097

AN8C21A

Purchased

No

250

Each

41.0000

2

2

\*\*

\*AN8C21A\*

BOLT

Location

Loc Qty

Loc Code

ST343

41

118758

3

121275

38

121275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi$  0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER

NO. 86257 MLC  
12/06/25

RELEASED  
68 07-2-14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS. CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 1 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

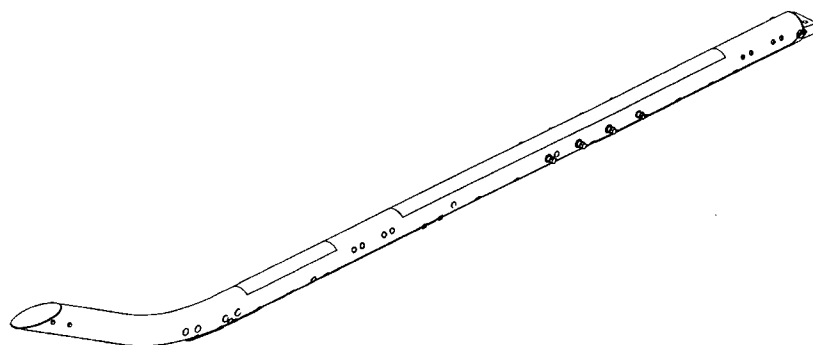
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

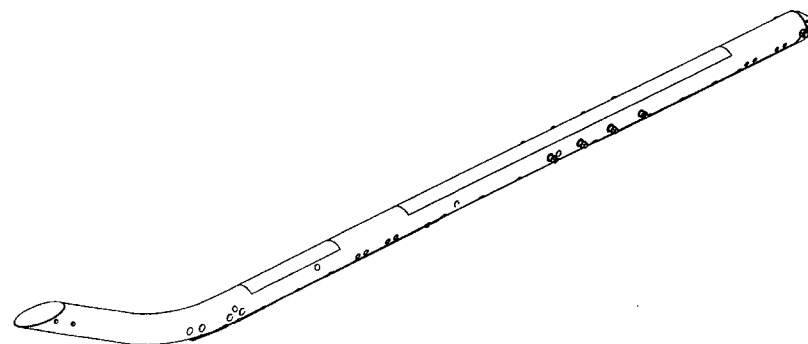
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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09.22.16

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PC	PORT HADLOCK, WA	
CHECKED	PC	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	PC	SHEET 2 OF 11	
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

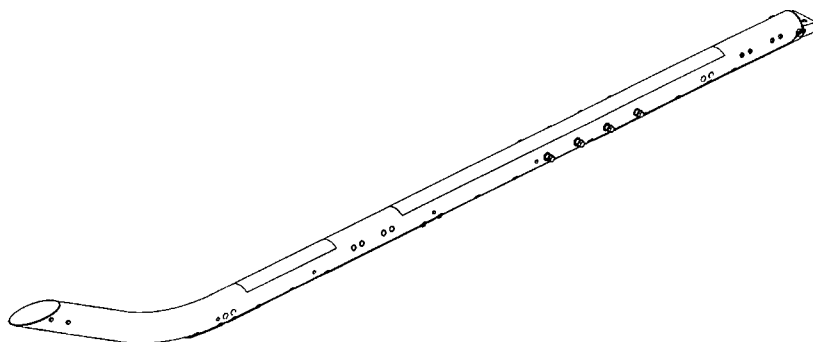
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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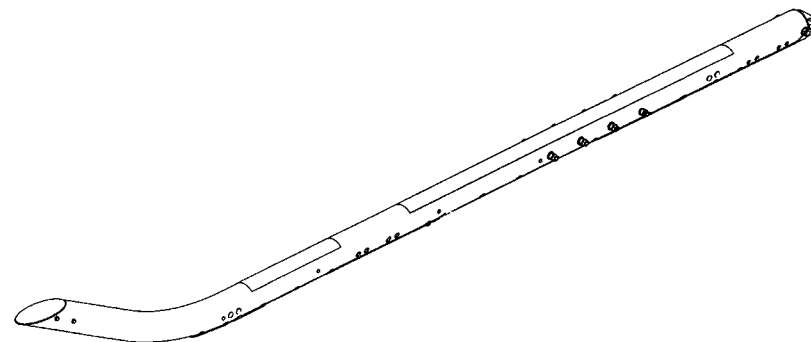
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86257



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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64-9-121M

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	JA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	SH	350 SKIDTUBE ASSEMBLY	NTS
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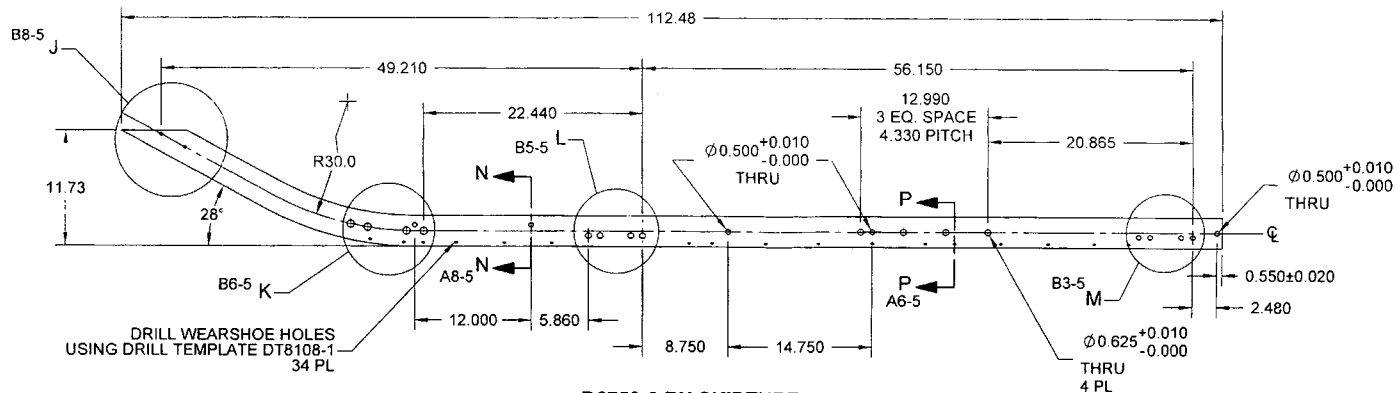
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

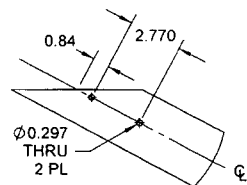
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

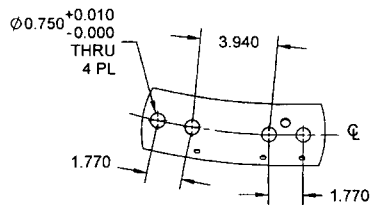
**NOTE:** Date & initial all entries



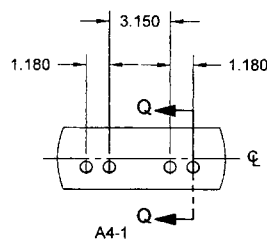
**D2750-2 RH SKIDTUBE**



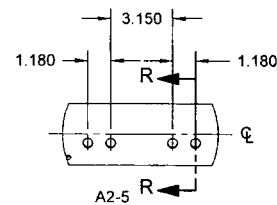
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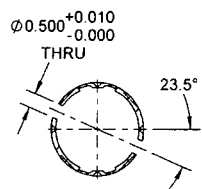
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SCALE 2X



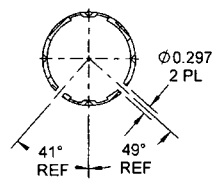
**DETAIL L**  
SCALE 2X



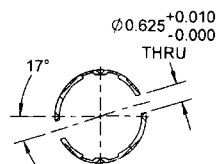
**DETAIL M**  
SCALE 2X



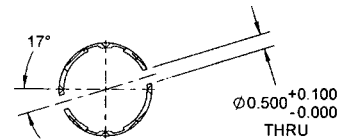
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN	PE	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PE	PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

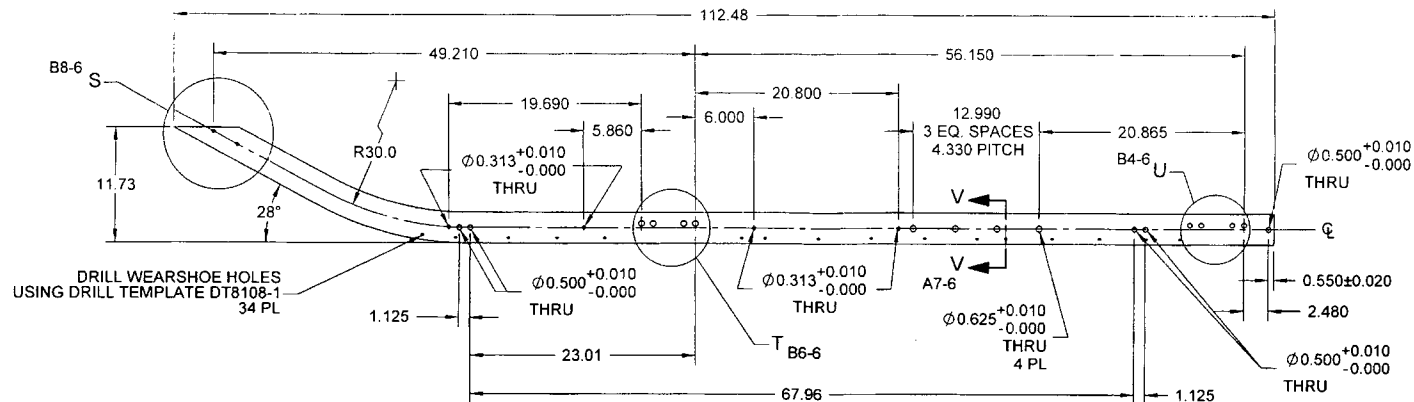
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

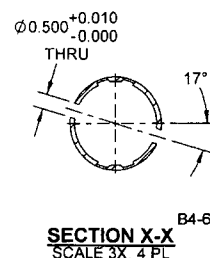
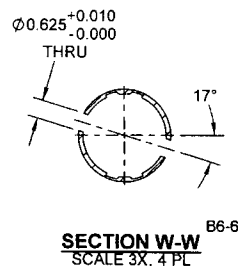
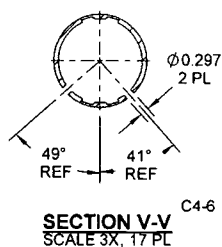
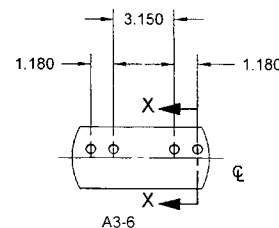
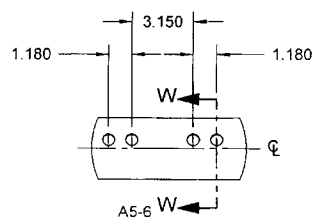
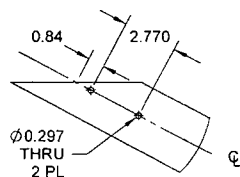
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D2750-3 LH SKIDTUBE**



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DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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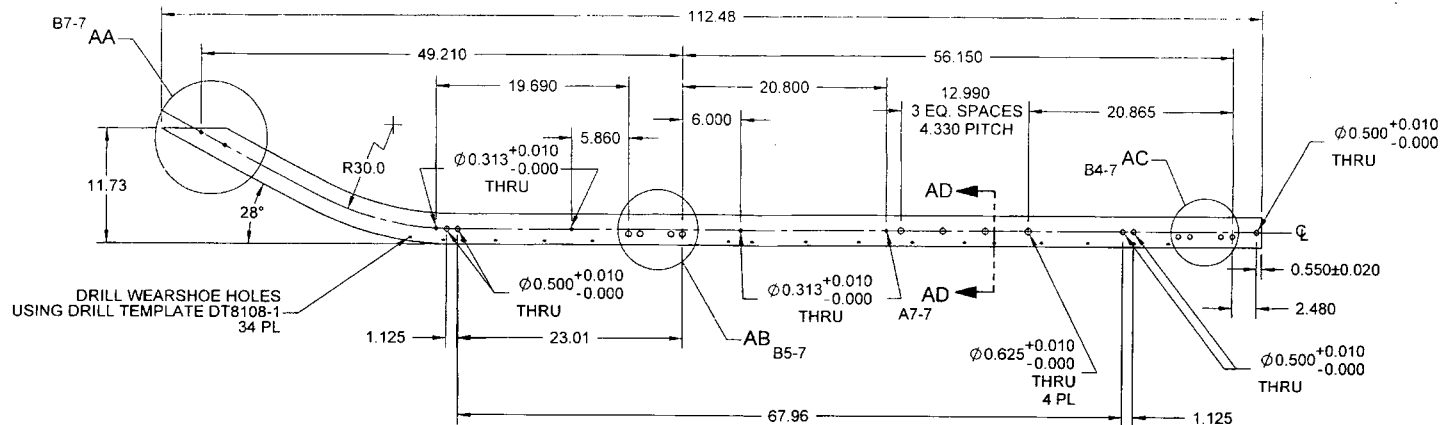
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

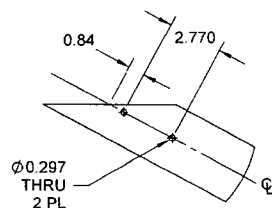
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

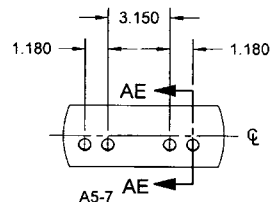
**NOTE:** Date & initial all entries



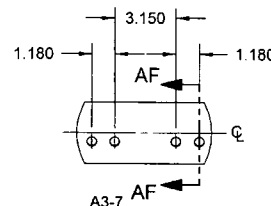
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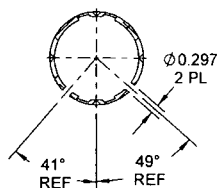
**DETAIL AA**  
D7-7  
SCALE 2X



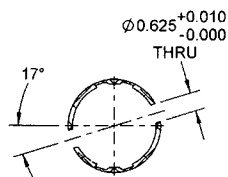
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C4-7  
SCALE 2X



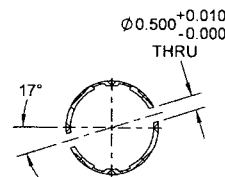
**DETAIL AC**  
D3-7  
SCALE 2X



**SECTION AD-AD**  
D3-7  
SCALE 3X, 17 PL



**SECTION AE-AE**  
B6-7  
SCALE 3X, 4 PL



**SECTION AF-AF**  
B4-7  
SCALE 3X, 4 PL

**RELEASED**  
08-09-2010

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

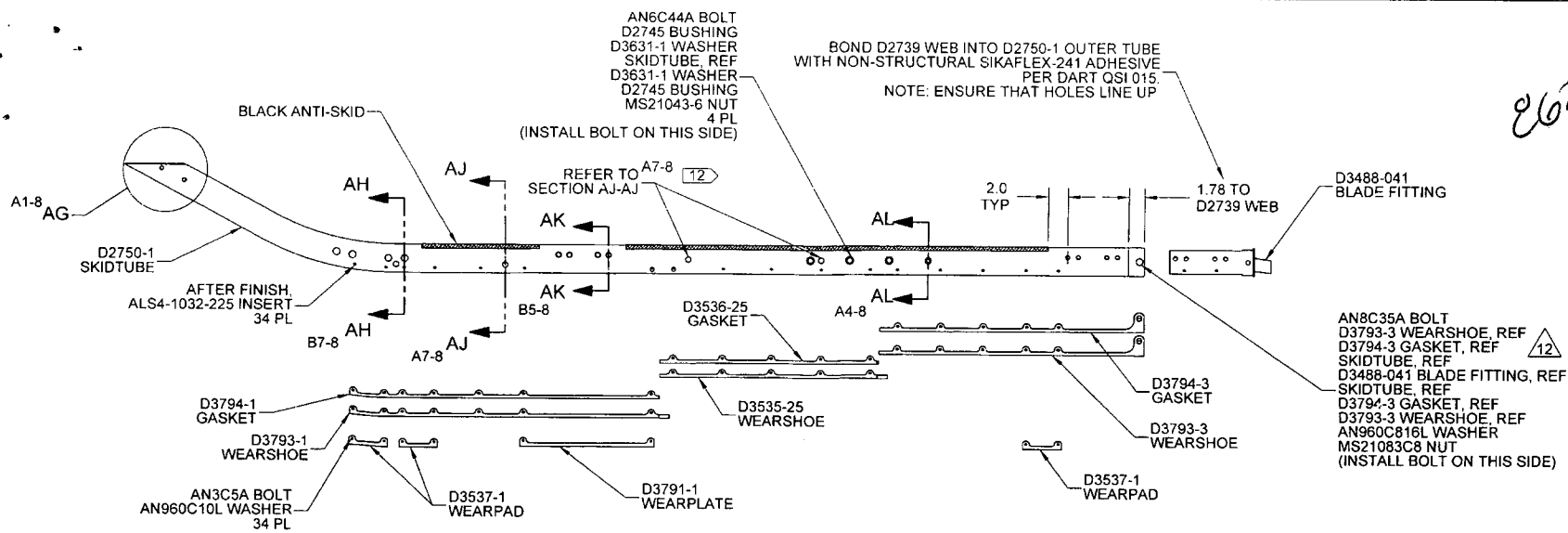
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

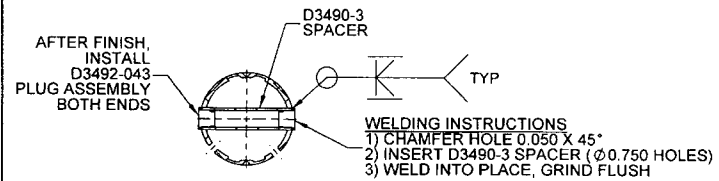
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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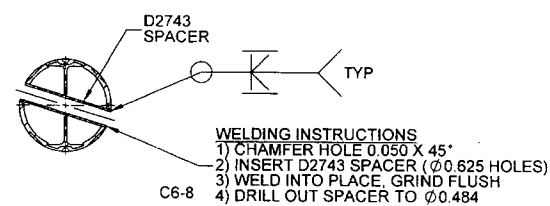
86257



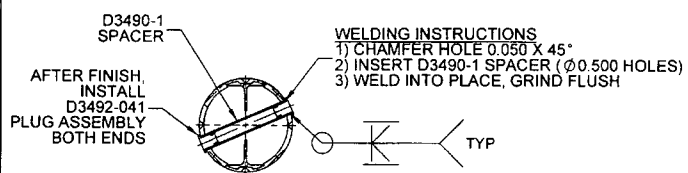
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



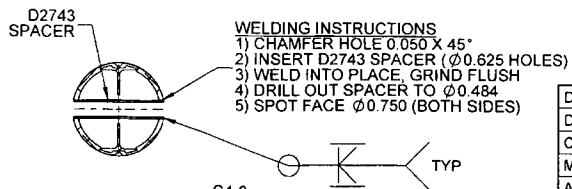
**SECTION AH-AH**  
SCALE 3X, 4 PL



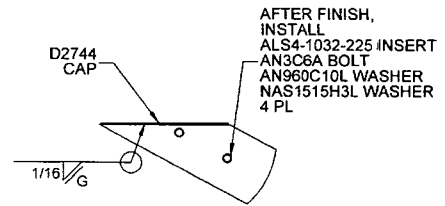
**SECTION AK-AK**  
SCALE 3X, 4 PL



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AG**  
SCALE 2X

**RELEASED**  
86257

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

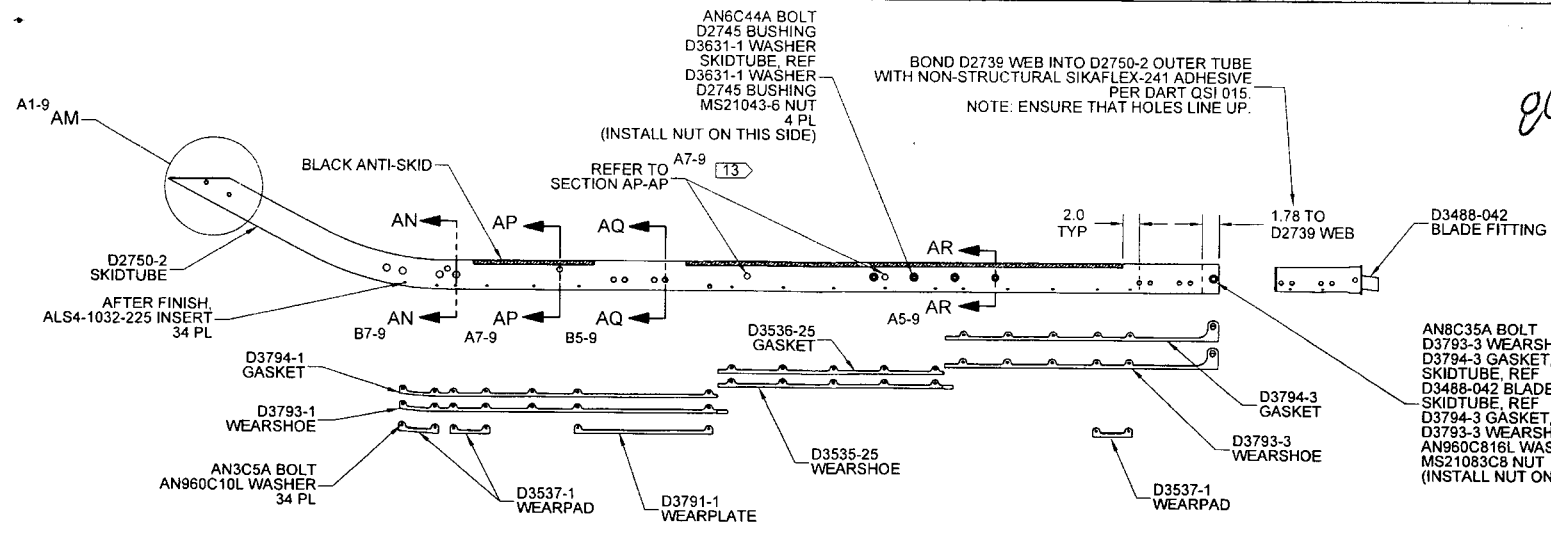
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

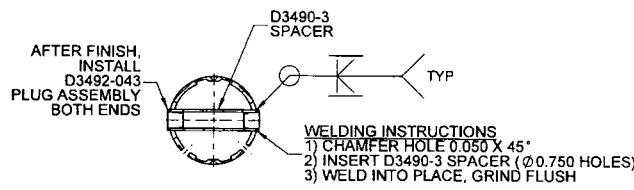
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

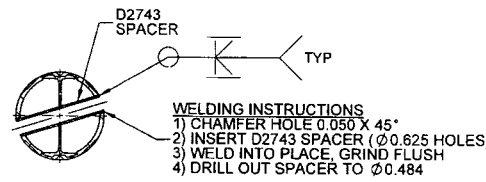
86257



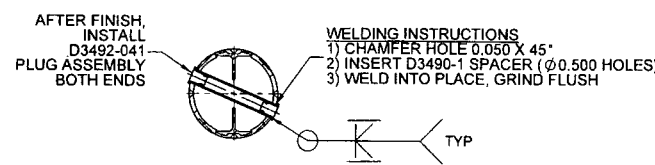
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



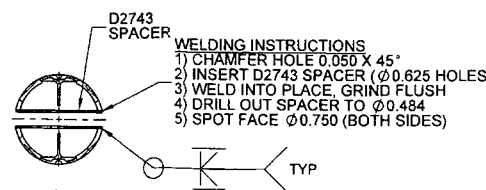
**SECTION AN-AN**  
SCALE 3X, 4 PL



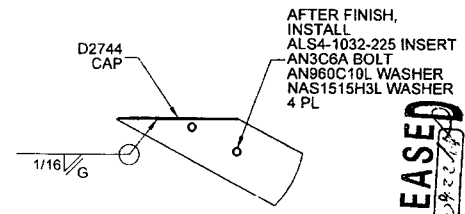
**SECTION AQ-AQ**  
SCALE 3X, 4 PL



**SECTION AP-AP**  
SCALE 3X, 4 PL



**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AM**  
SCALE 2X

DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 9 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
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RELEASED  
08/22/2016

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

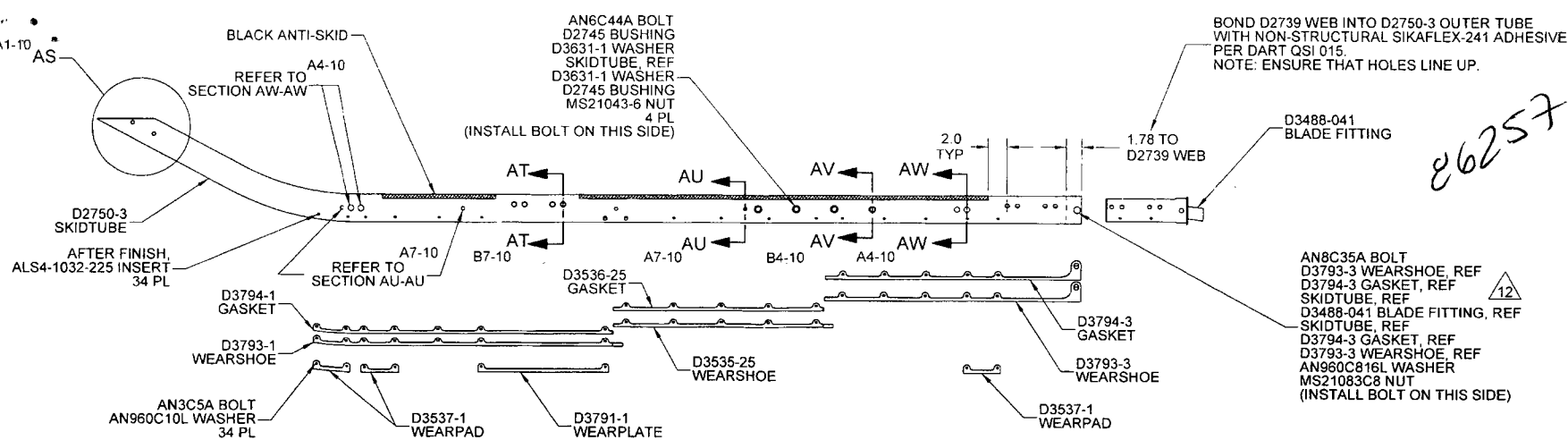
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

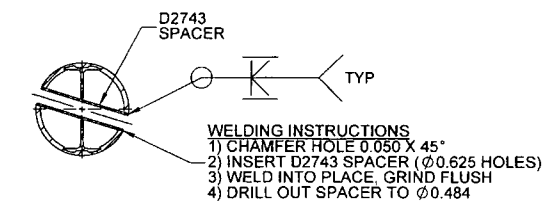
**NOTE:** Date & initial all entries



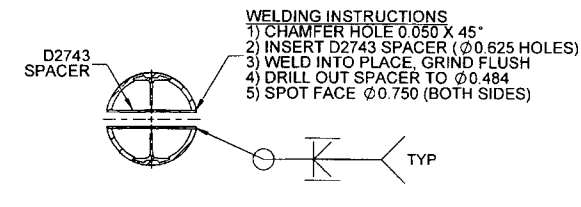
8 7 6 5 4 3 2 1



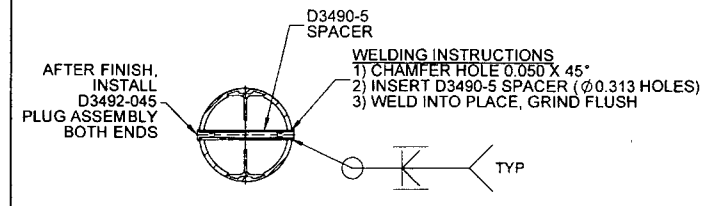
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



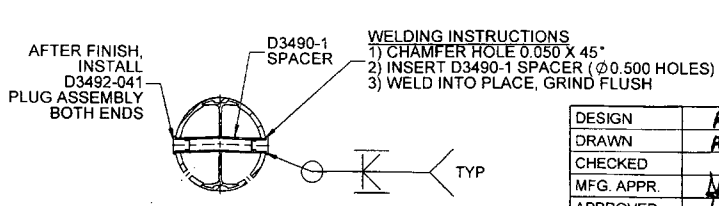
**SECTION AT-AT**  
SCALE 3X, 4 PL



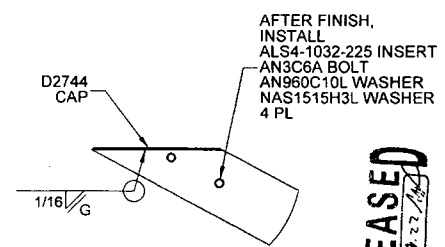
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL



**DETAIL AS**  
SCALE 2X

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		TITLE	SHEET 10 OF 11
APPROVED		<b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
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**RELEASED**  
2016-07-27

86257

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 298

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: 87012  
Part #: A350-636-014  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Penetration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Fusion:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Cracks:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Overlap (cold lap)	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Undercut:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Pin holes:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Porosity (surface):	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Coloration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Burn through:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]

Qualifier David Reed Date of Test Coupon 12.07.23  
Welder Barclay Elliott Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld